

Work Order ID 59195

May 27, 2010 2:39:22 PM



Page 1

Item ID: D3779-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Plate

Start Date: 5/27/10

Start Qty: 2.00



Cust Item ID:

Required Date: 5/27/10

Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

u

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3779

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3779

☐ Dwg Rev: A

☐ Prog Rev: A

☐ 2-

Deburr if necessary

1310-5-27

5

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

1310-5-27

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8/10/12

(+2)

Work Order ID 59195

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Page 2

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Start Date: 5/27/10

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Cust Item ID:

Required Date: 5/27/10

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Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

Hand Finishing

② BR 10-5-31

140



QC

QC3- Inspect Part Finish

0.00

Memo

0.00

Quality Control

H 10/05/31

2 φ

150



Packaging

Identify as per dwg & Stock Location: 87

0.00

Memo

0.00

Packaging

10-5-31 (20) φ

Work Order ID 59195

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Page 3

Item ID: D3779-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Plate

Start Date: 5/27/10

Start Qty: 2.00



Cust Item ID:

Required Date: 5/27/10

Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/01

10-6-01
②

Picklist Print

May 27, 2010 2:39:21 PM

Page 1

Work Order ID: 59195

Parent Item: D3779-3

Parent Item Name: Plate

Comments: IPP Rev:A 08-07-21 new issue DD verified by:ec

Start Date: 5/27/10

Required Date: 5/27/10

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.050		Purchased	No			100	sf	39.5000	0.1937	0.407789			



6061-T6 .050 Sheet



1810-5-27

Location

Loc Qty

Loc Code

MAT21

39.5

110791

4.5

113216

32

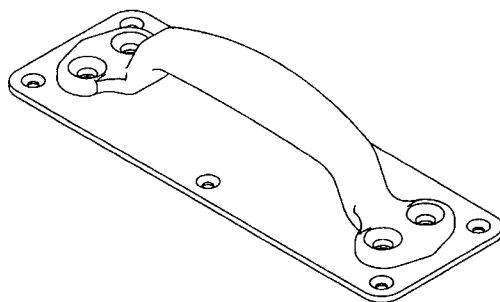
17349

3

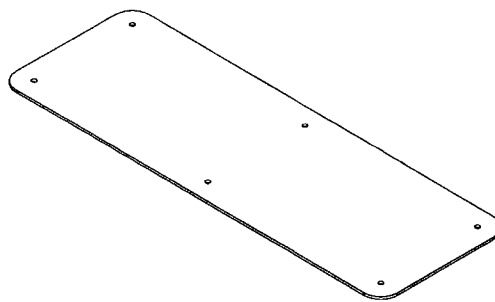
113216

②

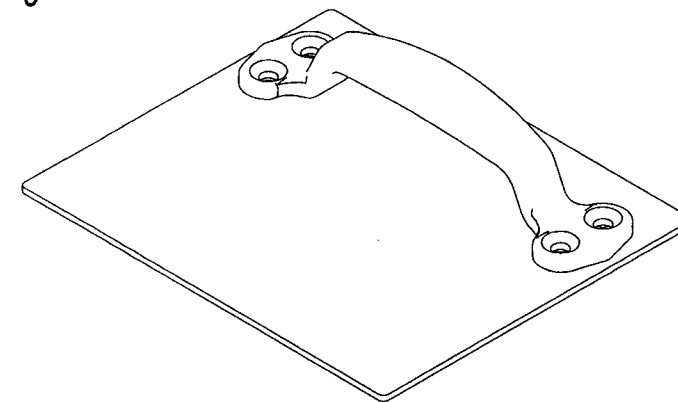
QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
X		D3779-041	HANDLE ASSEMBLY
	X	D3779-043	HANDLE ASSEMBLY
1	1	D3203-1	HANDLE
1		D3779-1	PLATE
	1	D3779-5	PLATE
4	4	MS20426AD10-8	RIVET, CSK



D3779-041 HANDLE ASSEMBLY
(EXTERIOR)



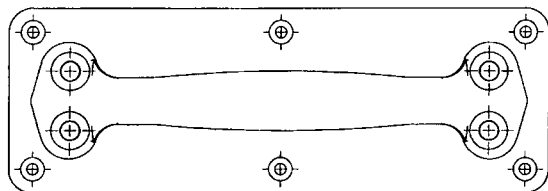
D3779-3 DOUBLER PLATE



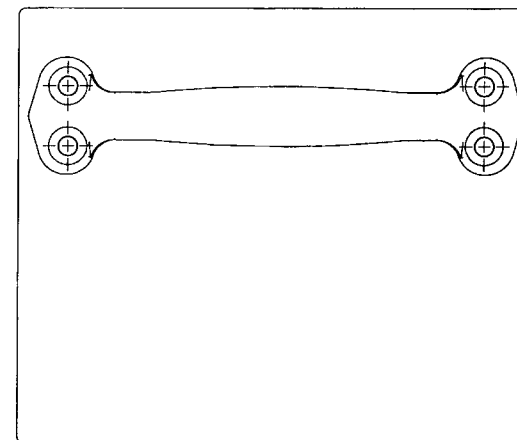
D3779-043 HANDLE ASSEMBLY
(INTERIOR)

RELEASED
08-06-26

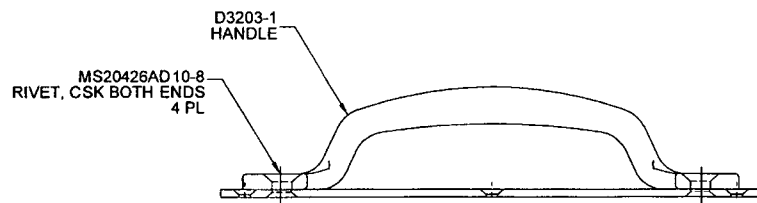
A	NEW ISSUE	AJS	08.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3779	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		HANDLE ASSEMBLY, CABIN SLIDING DOOR	NTS
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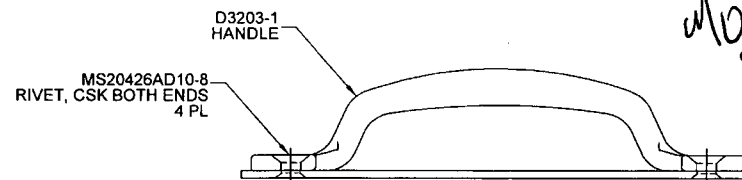
D3779-1
PLATE



D3779-5
PLATE



D3779-041 HANDLE ASSEMBLY
(EXTERIOR)




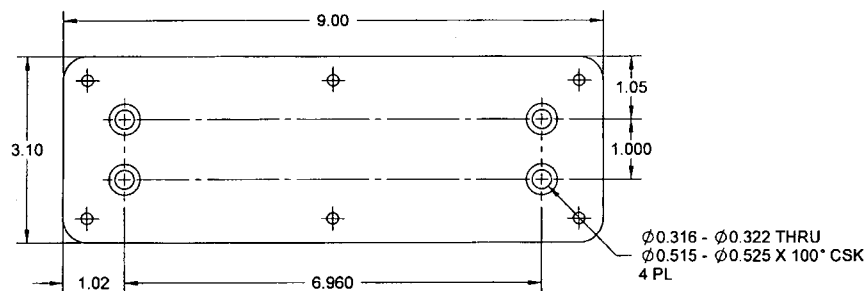
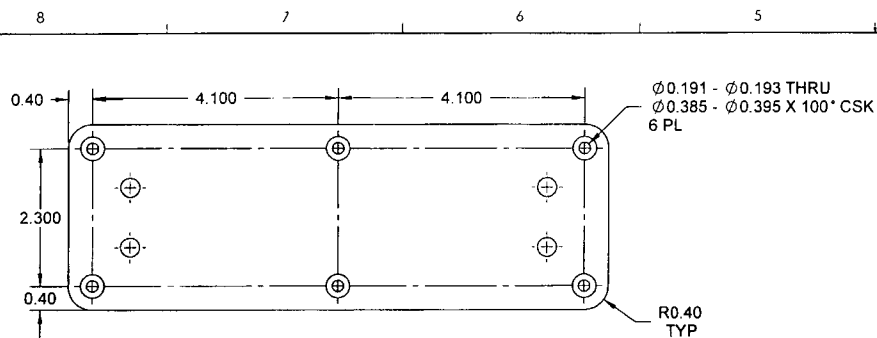
D3779-043 HANDLE ASSEMBLY
(INTERIOR)

NOTES:

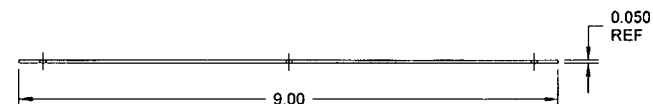
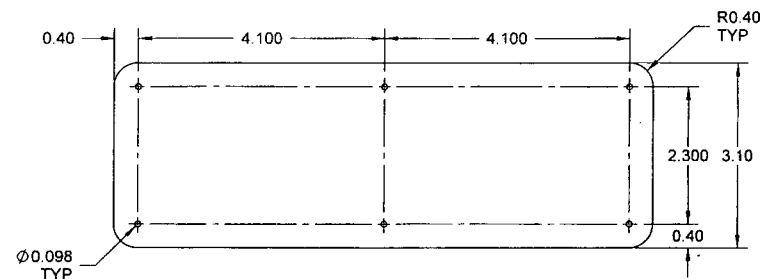
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3779-041" USING FINE POINT PERMANENT INK MARKER
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3779-043" USING FINE POINT PERMANENT INK MARKER
- 8) WEIGHT: 0.71 lbs APPROX (-041)
- 9) WEIGHT: 1.14 lbs APPROX (-043)

RELEASED
08-06-26 1/18

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D3779-1 PLATE



D3779-3 PLATE

NOTES:

1) MATERIAL: -1 PLATE:

6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.125

-3 PLATE:

6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.050

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED





4) UNITS: INCHES UNLESS OTHERWISE NOTED

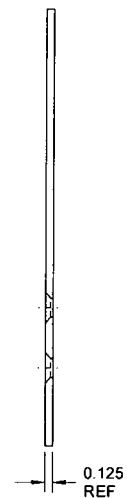
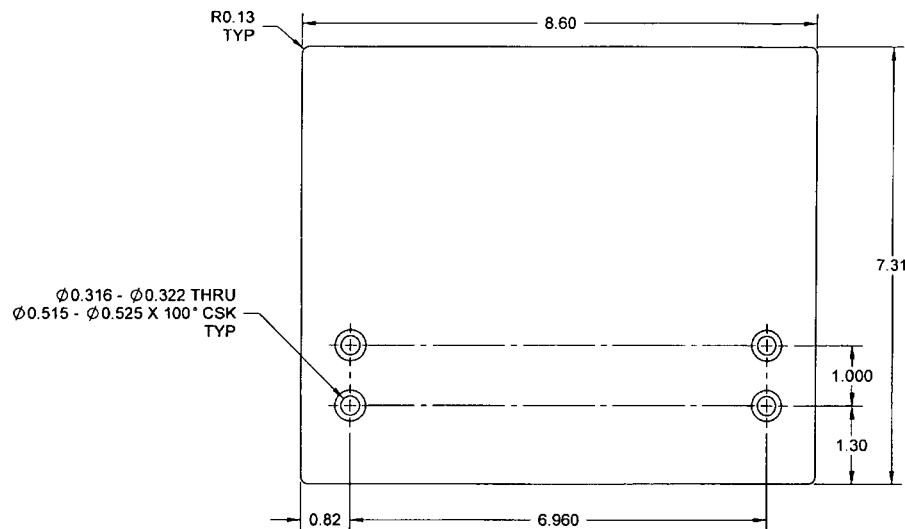
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

**6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3779-3" USING FINE POINT PERMANENT INK MARKER
(DO NOT IDENTIFY -1 & -5)**

7) WEIGHT: 0.14 lbs FOR -3.

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08-05-26/10

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MFG. APPR.		D3779	SHEET 3 OF 4
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DE APPR.		HANDLE ASSEMBLY, CABIN SLIDING DOOR	
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


W/S 59195

NOTES:

- 1) MATERIAL: -5 PLATE:
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE SHEET 2 FOR ASSEMBLED WEIGHT

RELEASED
08-06-26

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DE APPR.		HANDLE ASSEMBLY, CABIN SLIDING DOOR	NTS
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